

Work Order ID 152809

Monday, January 16, 2017 7:27:03 AM

152809

Page 1

Item ID: D2230-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 12/6/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: DAS 13 9-89 Date: JAN 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2230	Rev G								
110	Outsource process - Machining HAAS CNC VERTICAL MACHINING #1	0.00							
110									
Outsource5	Memo	2,783.22							
Outsource process - Machining	Issue P/O to Metec : <u>34979</u> Machine as per dwg C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.17							
Packaging	Ensure C of C is attach								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.25							
Quality Control									

MAR 07 2017

Work Order ID 152809

Monday, January 16, 2017 7:27:03 AM

152809

Page 2

Item ID: D2230-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 12/6/2016 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 12/15/2016 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo <i>N/A</i> DAS 38 9-89 0.17	0.00							
150 *150* QC Quality Control	QC7-Inspect Chemical Conversion Coat Memo <i>N/A</i> DAS 38 9-89 0.08	0.00							
160 *160* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____ <i>N/A</i> DAS 38 9-89 0.69	0.00							

Monday, January 16, 2017 7:27:03 AM

Page 3

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170						<u>50</u>			
QC	Memo	0.17							
Quality Control									DAS 38 9-89 MAR 07 2017
180	Identify as per dwg & Stock Location: <u>51505A</u>	0.00							
180						<u>50</u>			
Packaging	Memo	0.08							
Packaging									DAS 6 9-89 MAR 05 2017
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.83							
Quality Control									17/3/8 [Signature]

MAR 08 2017

Picklist Print

Monday, January 16, 2017 7:27:02 AM

Page 1

Work Order ID: 152809

152809

Parent Item: D2230-1

D2230-1

Parent Item Name: Mounting Lug

Start Date: 12/6/2016

Required Date: 12/15/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP D00.11.01 Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P		Purchased	No				Each	0.0000		50			
D2230-1P									**				
Lug													
D2423		Manufactured	No			110	f	422.4855	0.0683	3.594737			
D2423									**				
Lug Extrusion													

50x split-e-l
3.594737
JAN 17 2017
DAS
13
9-09

Location

Loc Qty

Loc Code

Metec

422.4855307

127892

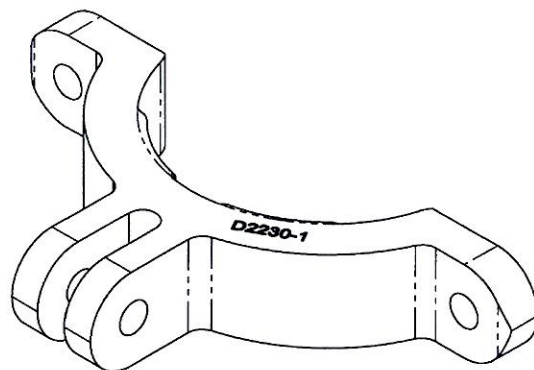
36.5122647

131451

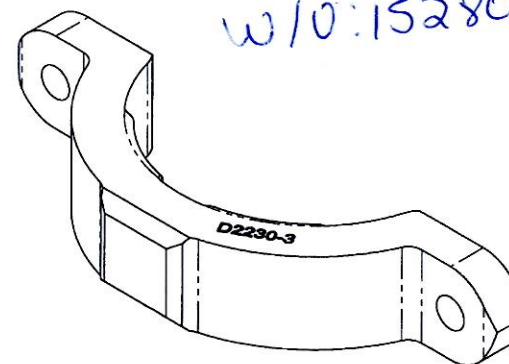
97.654451

148835

288.318815



D2230-1 MOUNTING LUG

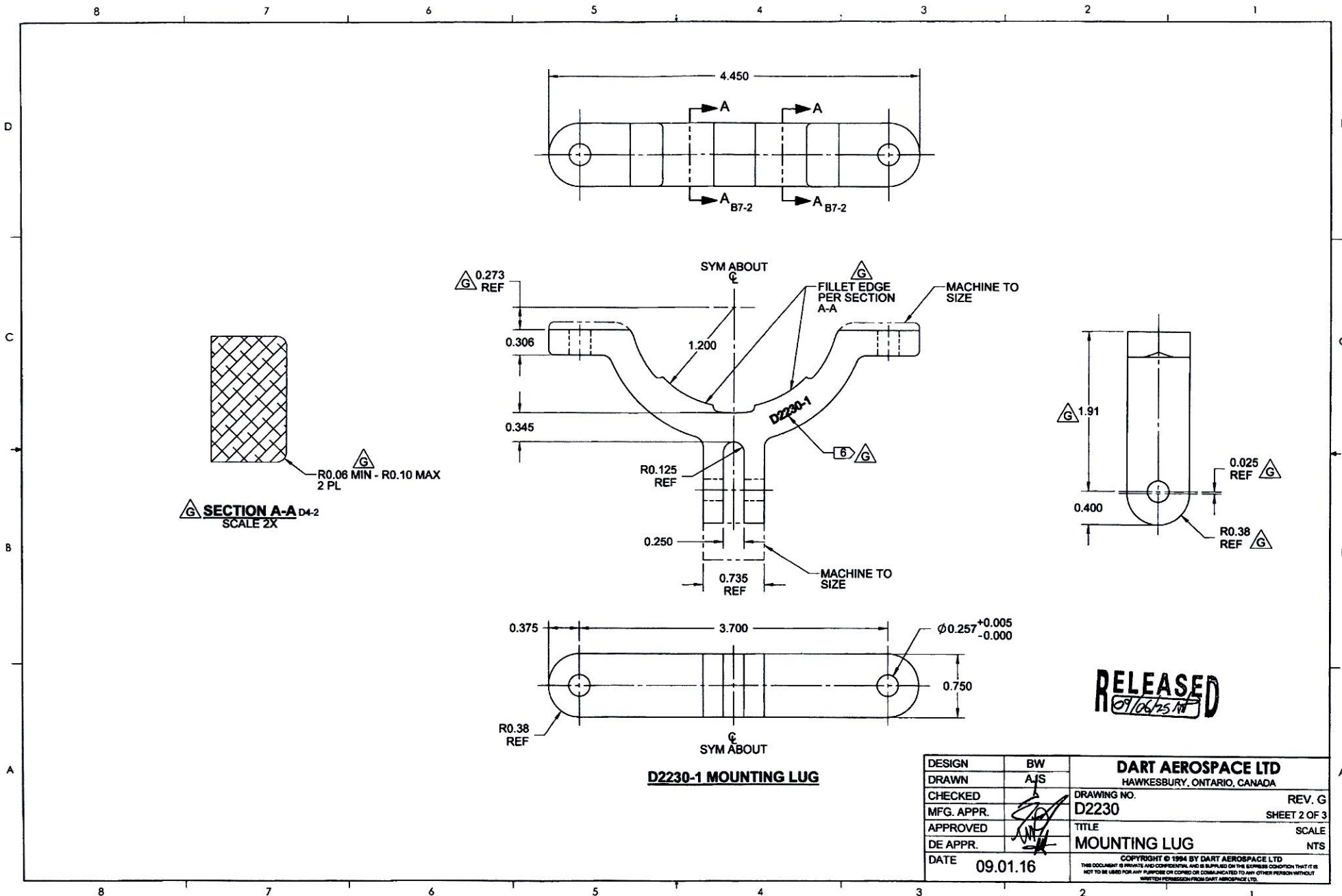


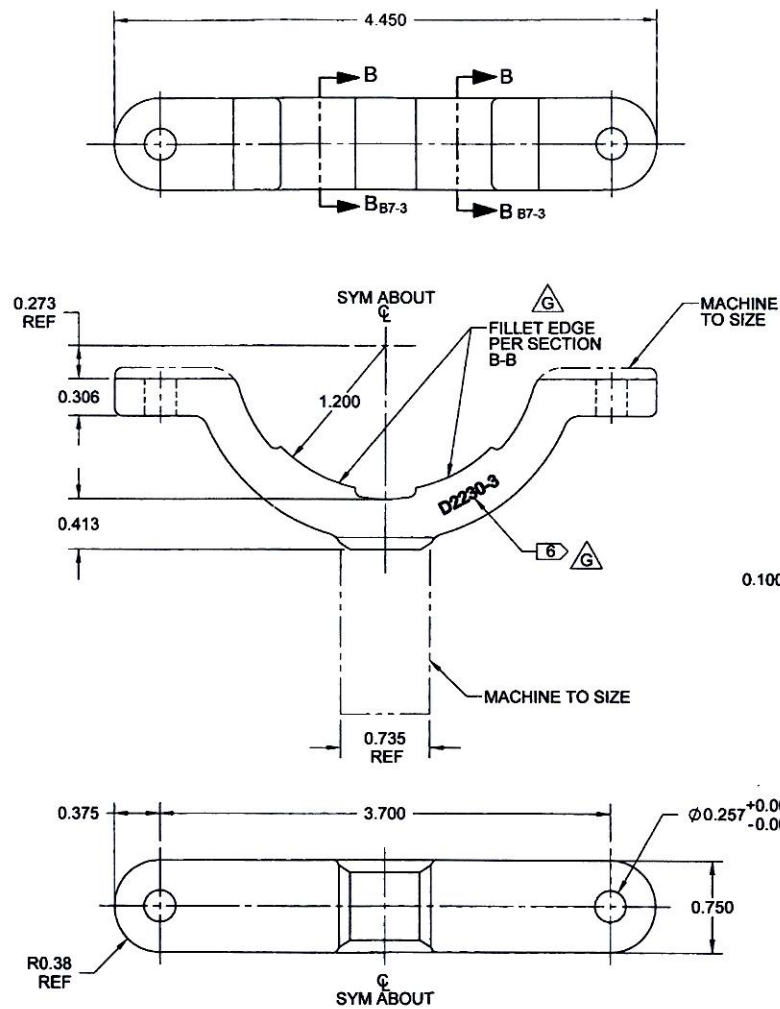
D2230-3 MOUNTING LUG

RELEASED
01/16/15 NM

G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:**
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
 - 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs





D2230-3 MOUNTING LUG

RELEASED
09/06/2016

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21565
Date: Feb 02, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 34979	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: Feb 02, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, as per drawing D2230-1 Rev G Alodine and Paint as per QSI 005	Each	50	50	
D3910-3 Crosstube Lug, as per drawing D3910-3 Rev E Alodine and Paint as per QSI 005	Each	30		
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

DAS
38
9-89

Received by

Spl7ed-6

Thank you for your order!



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

OUTSTANDING PO REPRINT

Purchase Order ID PO34979

Purchase Order Date 1/17/2017

PO Print Date 2/6/2017

Page Number 1 of 3

Order From : VC-MET003
METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To : DART AEROSPACE LTD
1270
ABERD
EEN
HAWKE
SBURY,
ON
K6A
1K7
CANAD
A

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	613 678 3957	Customer POID	
Vendor Fax	613 678 3956	Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	CAD
		FOB	Destination-Collect
Ship Method	Dart Truck		
Ship Acct			

Line Nbr	Item ID Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable	Req Qty	Extended Price
1	D2230-1P	Lug	2/9/2017 Yes 2/9/2017	50.00 Each	\$805.00
AS PER DWG D2230 REV. G 152809 ALODINE AND PAINT AS PER QSI 005					

DAS
38
9-89

SP17 026
Line Total:

\$805.00

2/6/2017



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2230-1	Lug Paint Batch # 20851 Material B148835	34979

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, February 02, 2017